

Shop 16/07

Work Order ID 60514

Tuesday, July 13, 2010 11:06:48 AM



Page 1

Item ID: D3955-7

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 7/13/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10-7-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3955	A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3955

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



Memo

0.00

Quality Control

M 10 07 14 (12)

ml 10 07 14 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

QC8- Inspect parts - second check

0.00

S.1310714

(12)

Quality Control

130



Packaging

Identify as per dwg & Stock Location: 102

0.00

Packaging 102

Packaging

Memo

0.00

140



QC

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

MF 100715
10-7-14

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Picklist Print

Tuesday, July 13, 2010 11:06:52 AM

Page 1 /1

Work Order ID: 60514



Parent Item: D3955-7



Parent Item Name: Plate

Start Date: 7/13/2010

Required Date: 7/20/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No				sf	119.1582	0.3545	4.477895 			

304/316 0.125 Sheet

Location	Loc Qty	Loc Code
MAT	119.1582	
114488	1.5259	
114799	117.6323	

ML 10-07-14

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DART AEROSPACE LTD	Work Order:	60514
Description: Plate	Part Number:	D3955-7
Inspection Dwg: D3955	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>MC. M</i>	Audited by:	<i>S</i>	Prototype Approval:	N/A
Date:	10/07/14	Date:	10/07/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	
B	09.11.04	Dimension 0.120 was 0.125	KJ	

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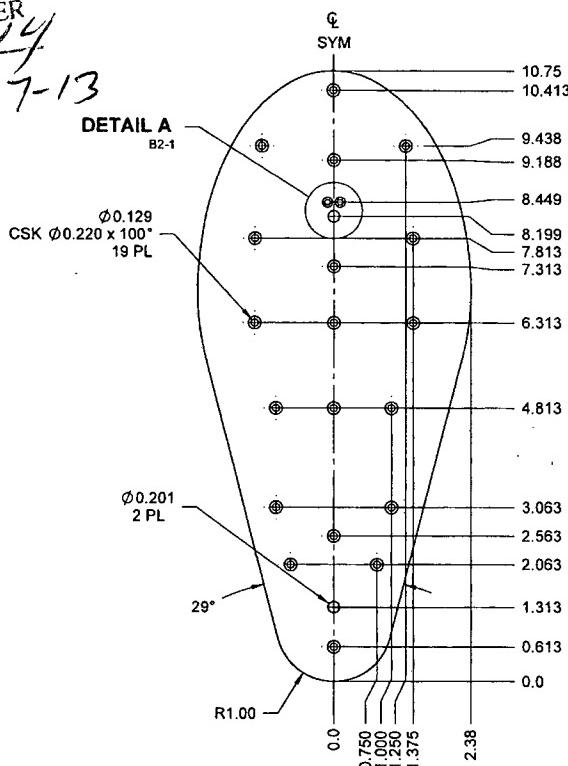
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SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 00514

PD 10-7-13



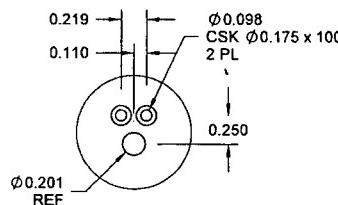
ITEM	QTY	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET

0.063
REF

INSTALL
MS21086L3 NUT PLATE
MS20427M3-3 RIVET, 2 PL

CSK SIDE

D3955-1
DOUBLER



DETAIL A
SCALE 2X D7-1



D3955-041 DOUBLER ASSEMBLY

RELEASED
09/07/21

D3955-1 NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER MS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

A	NEW ISSUE		RF	09.07.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	RF	DART AEROSPACE LTD	
DRAWN	RF		HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO.	
MFG. APPR.			REV. A	
APPROVED			D3955	
DE APPR.			SHEET 1 OF 5	
DATE	TITLE		SKIDTUBE TUNING KIT	
09.07.21	SCALE		NTS	

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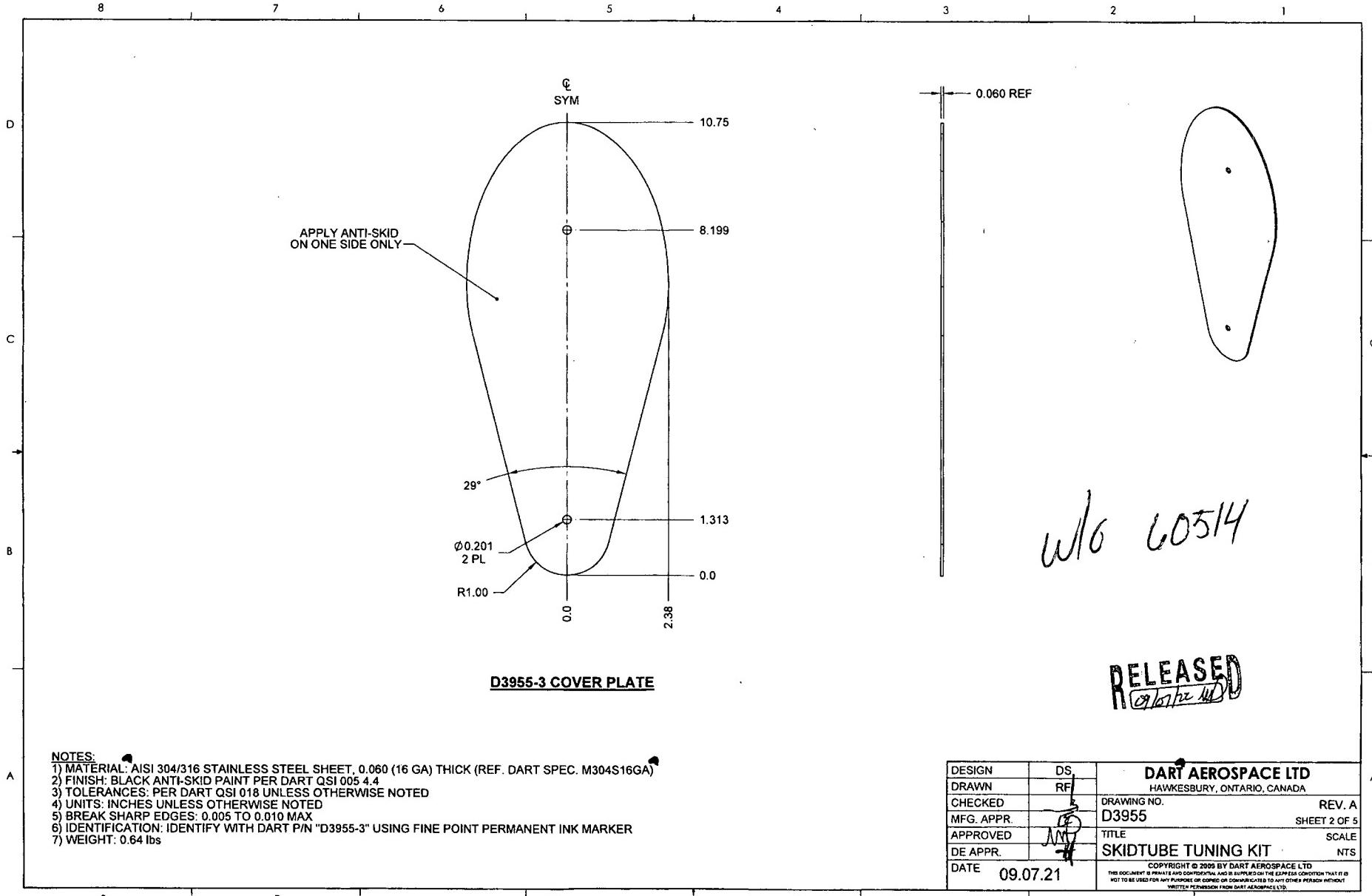
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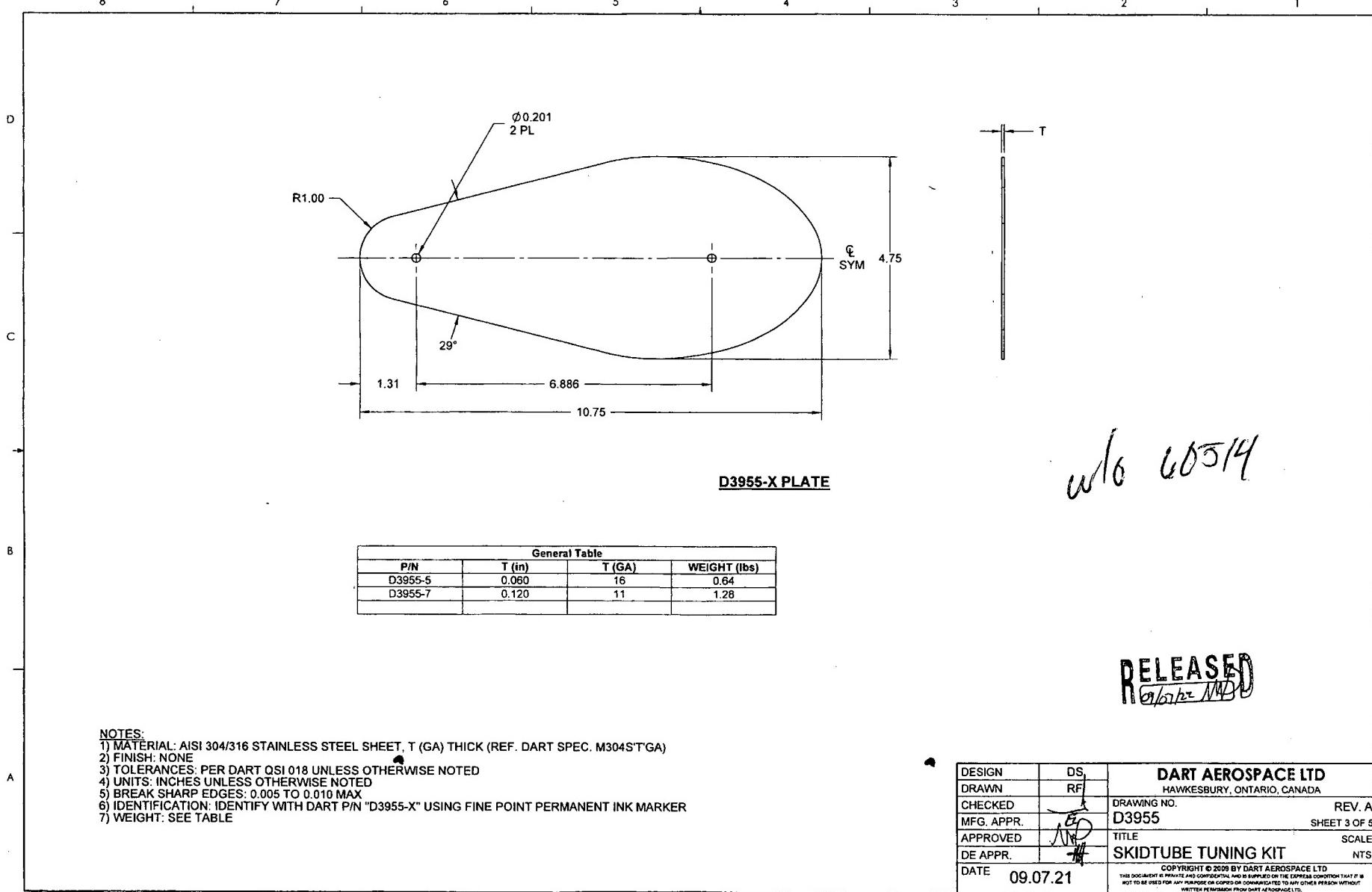
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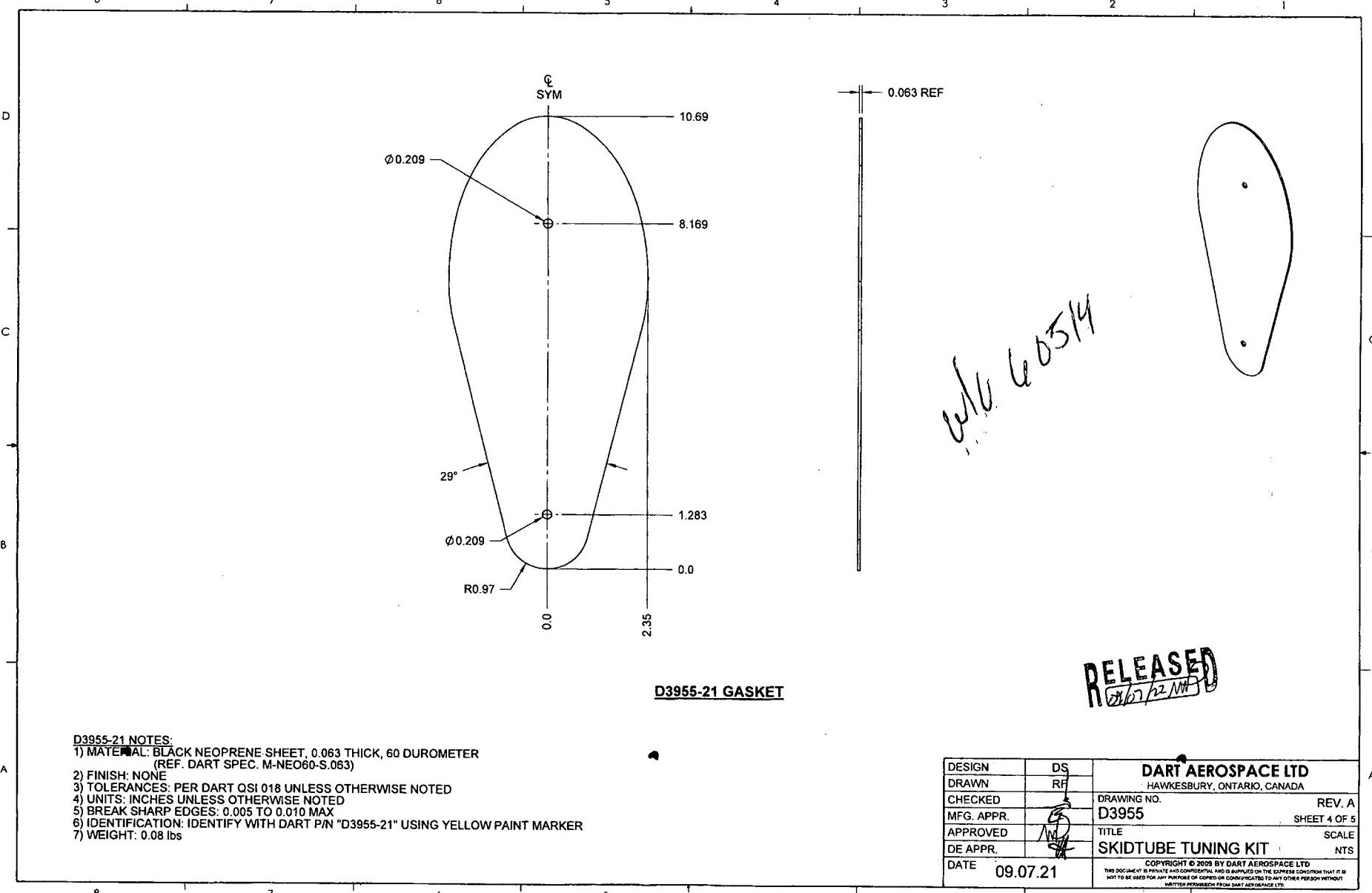
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DESIGN	DS	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. A
MFG. APPR.		D3955
APPROVED		SHEET 4 OF 5
DE APPR.		TITLE
DATE	09.07.21	SCALE
		NTS

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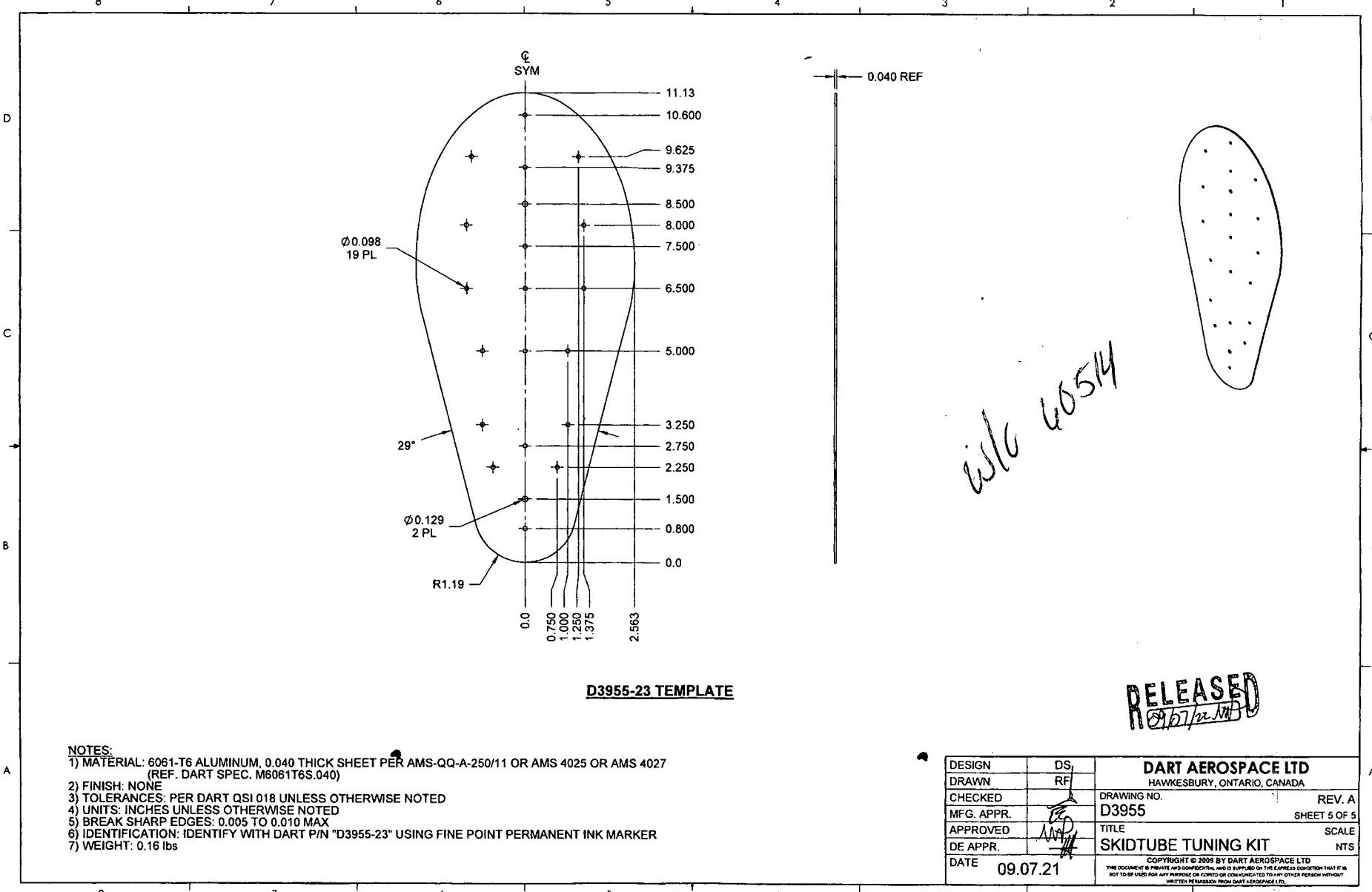
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